

Work Order ID 68156

Thursday, April 07, 2011 9:54:56 AM



Page 1

Item ID: D4323-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: N1 Access Cover, LH

Start Date: 4/7/2011 Start Qty: 1.00



Cust Item ID:

Customer:

PRELIMINARY ISSUE

[Signature]

Required Date: 4/7/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *MF*

Date: 11-04-07 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4323	PA1 PA0 <i>DL 11/04/07</i>								<i>ADJ</i>
100		0.00							

HandThermo	Memo	0.00							
Hand Finishing Thermoforming	I-Cut Sheet to required Blank size								<i>DL 11/04/07</i>

105		0.00							
HandThermo	Dry Material	0.00							
Hand Finishing Thermoforming	Memo								
	Dry Sheet as per QSI022 KYDEX								<i>DL 11/04/07</i>

Temp: 150° F

Time IN: 4:30 pm *11/04/06*

Time OUT: 7:00 am *11/04/07*

Work Order ID 68156

Thursday, April 07, 2011 9:54:56 AM

Page 2

Item ID: D4323-3

Accept

Revision ID: PRELIM

Item Name: N1 Access Cover, LH

Start Date: 4/7/2011 Start Qty: 1.00

Required Date: 4/7/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg D4323-3 and Folio FTA096 using tool DT9711
Dwg Rev: P48
Folio Rev: A.

0.00

0.00

x1

Wh
11/04/07

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Visually inspect part for proper formation and texture

0.00

x1

Wh
11/04/07

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

x1

BB
11/04/07

Work Order ID 68156

Thursday, April 07, 2011 9:54:56 AM



Page 3

Item ID: D4323-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: NI Access Cover, LH

Start Date: 4/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

N/A.

1/2

PTO.
LAST PAGE

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Parts sent untrimmed

8/2/2011

Work Order ID 68156

Thursday, April 07, 2011 9:54:56 AM



Page 4

Item ID: D4323-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: N1 Access Cover, LH

Start Date: 4/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Packaging

Memo

0.00

0.00

Packaging

180



QC

Memo

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

11/5/16

W1104.07

RD2370

POSITIVE RECALL

EFFECTIVE 11/04/07 AUTH

RELEASED DATE 11/05/13

DART AEROSPACE LTD		Work Order: 68156
Description:		Part Number: D4323-3
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>Dhr</u>	Date: <u>11/04/07</u>
--------------------------------	------------------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>L 93°</u>	<u>1/2°</u>	<u>93°</u>	✓			
<u>0.040"</u>	<u>MIN.</u>	<u>0.060"</u>	✓			

Measured by: <u>Dhr</u>	Date: <u>11/04/07</u>
Audited by: <u>8 Part sent untrained</u>	Date: <u>11/04/07</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

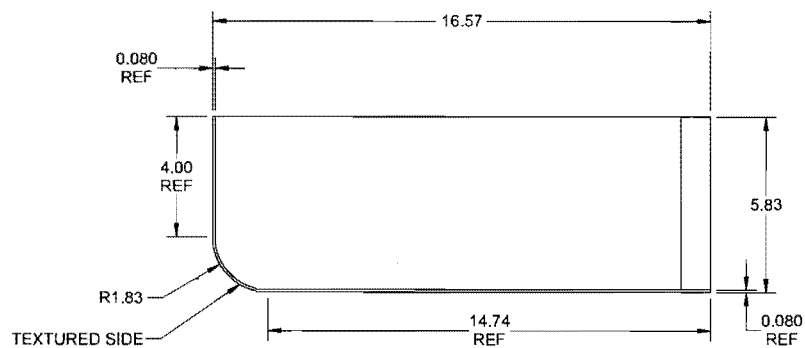
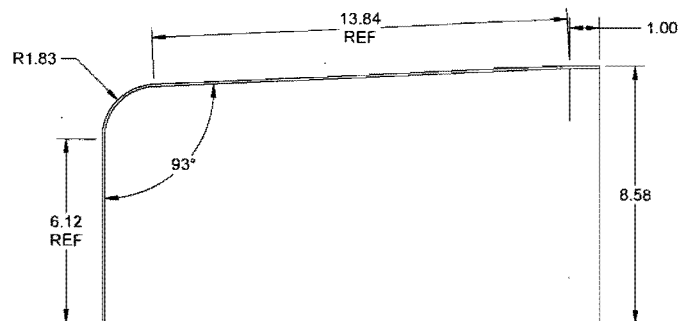
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

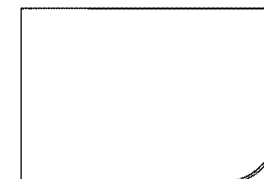
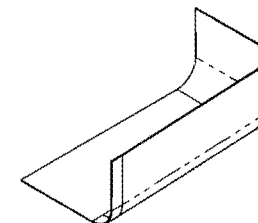
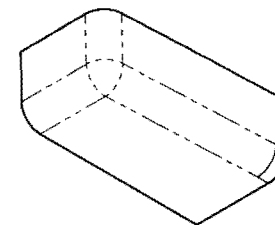
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4323-3 N1 ACCESS COVER, LH
D4323-4 N1 ACCESS COVER, RH (OPPOSITE)

#68152



**PRELIMINARY
ISSUE**

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 2.01 lbs
- 8) TOOLING: THERMOFORM -3 PART PER MOLD DT9711, AND -4 PART PER DT9712. TRIM PER MOLD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA8
MFG. APPR.		D4323	SHEET 3 OF 15
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.02.09	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION THROUGH DART AEROSPACE LTD.</small>	

3

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

The information contained in this transmission is privileged and confidential and intended only for the use of the individual or entity to whom it is addressed. If you are not the intended recipient, you are hereby notified that any distribution, copying, disclosure or taking of any action in reliance on the contents of this transmission is strictly prohibited and review by any individual other than the intended recipient shall not constitute waiver of privilege. If you have received this transmission in error, please notify me immediately and delete the original transmission.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Friday, April 01, 2011 4:22 PM
To: Eric Charbonneau
Cc: 'Daryl Leger'; 'Jean-Luc Menard'; 'Linda Lacelle'; Bill Beckett; 'Harvey Siemens'
Subject: D4323 Parts

Hi Eric,

I have put D4323-PA7 in the Prelim folder.

I have also created dxfs for the -23/-25 although I'm not sure if you need them since these parts will need to be thermoformed to obtain the finished/beveled/tapered edge. I didn't create a dxf for the -24 because it is the same outline as the -23, but finished edge is on the opposite side for the -24. (Please call me if I'm confusing you on this.)

We need another set of the D4323-19/-20 cabin posts. The -19 is too narrow – I have added 2.0" to it. It can be left untrimmed and the guys here will trim it to fit the aircraft exterior. We also need another -20 since the one that arrived yesterday (Mar. 31) was damaged.

I have also modeled and drawn up the remaining kydex parts -23/-24/-25.

Here's the list:

Qty	P/N	Description	Notes
1	D4323-19	Cabin Side Post, LH	Pls leave the part untrimmed by at least 2.0" inches as indicated in the drawing.
1	D4323-20	Cabin Side Post, LH	Pls leave the part untrimmed by at least 2.0" inches as indicated in the drawing.
1	D4323-23	Access Panel, LH	New part – requires a finished/beveled/tapered edge as indicated
1	D4323-24	Access Panel, RH	New part – requires a finished/beveled/tapered edge as indicated
1	D4323-25	Panel, Glove Box	New part – requires a finished/beveled/tapered edge as indicated

Cheers,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

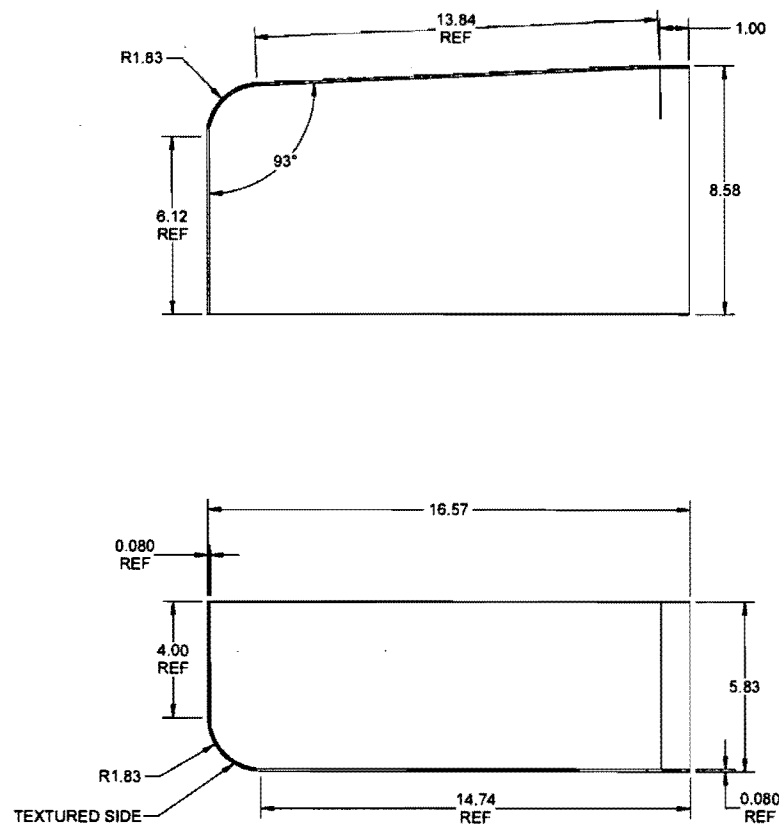
W/O: 68156		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/07	140	PARTS NOT Pre-trimmed. Customer will trim to fit as per attached e-mail.	Sh	11/04/07	1		

Part No: D4323-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

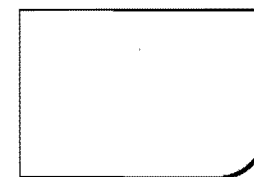
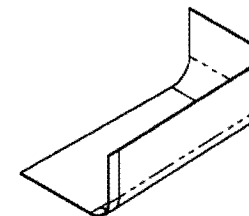
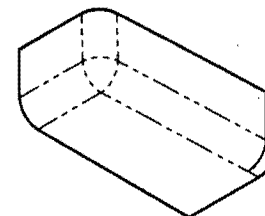
NOTE: Date & initial all entries









D4323-3 N1 ACCESS COVER, LH
D4323-4 N1 ACCESS COVER, RH (OPPOSITE)

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
 REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 2.01 lbs
- 8) TOOLING: THERMOFORM -3 PART PER MOULD DT9711, AND -4 PART PER DT9712 AND PER DART QSI 022. TRIM PER MOULD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4323	SHEET 3 OF 15
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.04.21	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

RELEASED
 2011-05-11
 MB

68156

